

Work Order ID 80812

February-29-12 1:31:46 PM

80812

Page 1

Item ID: D2512

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Basket Lid 205/350

Stop ***NS2***

Start Date: 29/02/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 08/03/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MLJDate: 12/02/29 Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2512

Rev E

100

Weld per dwg A/R S.S. rod Batch 118366 0.00***100***

Large Fab


Large Fab

Memo

0.00

Large Fab

1-Cut 3/4" x 3/4" square tubing as per Dwg D2512
2-Cut (4) D2236 From D3166-3
3-Drill holes in D2512-1 as per Dwg D2512 using Drill Jig DT8305
4-Weld as per Dwg D2512 using Welding Jig DT 9436
Deburr as required
INSTALL D2012-117 CLEVIS ONLY ON D130-701-041

Pl 12.03.13 1x 

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00

110

QC

Memo

0.00

Quality Control

 12.03.13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC6- Inspect dimensions to drawing

0.00

120

QC

Memo

0.00

8/26/13

Quality Control

125

Pressure Wash per QSI005 4.3

0.00

125

HandFinish

Memo

0.00

Hand Finishing

IXØ m/f 12/03/13

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Reference:

Approvals:

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Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

130

Powdercoat

Memo

0.00

Powder Coating

1- Plug holes in D2581 and in D2327-1 bushing prior to Powdercoat

1ST COAT:

START TIME: 11h25

OVEN TEMPERATURE: 400°F

FINISH TIME: 11h55

m120 222

2ND COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

140

HandFinishing

0.00

140

HandFinish

Memo

0.00

Hand Finishing

Wing Walk and Spray Paint black as per Dwg D2512 and QSI 005 4.4

Batch:

MT2012S

m120817 SPRAYPAINT

12/03/15

Dart Aerospace Ltd

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Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC3- Inspect Part Finish	0.00							
150									
QC	Memo	0.00							
Quality Control									
160	Identify as per dwg & Stock Location: <i>G.A</i>	0.00							
160									
Packaging	Memo <i>w/o 80810</i>	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

1-4-12-12-15

2/2/15

12/3/16

ME 12-03-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

February-29-12 1:31:50 PM

Page 1

Work Order ID: 80812

80812

Parent Item: D2512

D2512

Parent Item Name: Basket Lid 205/350

Start Date: 29/02/2012

Required Date: 08/03/2012

Start Qty: 1.00

Required Qty: 1.00

Comments:

Rev IPP:M03.01.31 AddedD2012-117forD130-701-041KJ/RF
IPP Rev:N06.04.05 Added level21 EC
IPP REV:O ADDED D3490-1/-3 FOR D130-701-011/-043 10-04-20 JLM
VERIFIED BY:DD
IPP Rev:P 08-08-29 revE as per dwg DD verified by:EC
IPP Rev:Q 08-09-24 plug holes prior to powder coating DD verified
by:EC IPP Rev:R
10.06.29 added pressure wash DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2012-117		Manufactured	No			100	Each	35.0000	2	2			
D2012-117									**				
Clevis													

Location	Loc Qty	Loc Code
WA005	35	
55729	4	
69890	31	

*** ONLY APPLICABLE ON D130-701-041 -IF
NOT USED, PLEASE MARK N/A ***

✓ D2232-1
Basket Hinge

Manufactured No

100 Each 8.0000 2 2

**

Location	Loc Qty	Loc Code
WA	8	
79472	8	
	100	
	Each	
	35.0000	
	2	

✓ D2327-1
Spacer Bushing

Manufactured No

100 Each 35.0000 2 2

**

Location	Loc Qty	Loc Code
WA005	35	
69728	9	
73692	26	

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Page 2

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Parent Item: D2512

Parent Item Name: Basket Lid 205/350

80812

D2512

Start Date: 29/02/2012

Required Date: 08/03/2012

Start Qty: 1.00

Required Qty: 1.00

D2506 Manufactured No

100

Each

11.0000

1

1

✓ *D2506*

Label Plate

**

Cpl 12-03-13

Location

Loc Qty

Loc Code

WA006

11

~~71142~~

1

~~79197~~

10

D2581 Manufactured No

100

Each

47.0000

2

2

✓ *D2581*

Mounting Bracket

**

Cpl 12-03-13

Location

Loc Qty

Loc Code

WA005

47

69739

1

70766

2

77045

15

77523

29

D3166-3 Manufactured No

100

Each

4.0000

1

1

✓ *D3166-3*

Basket Hoop

**

Cpl 12-03-13

Location

Loc Qty

Loc Code

WA007

4

77294

4

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Page 3

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D2512

Parent Item Name: Basket Lid 205/350

Start Date: 29/02/2012

Required Date: 08/03/2012

Start Qty: 1.00

Required Qty: 1.00

M304EX0.75-16F

Purchased

No

100 sf

575.3277

18

18.94737

**

M304EX0 75-16F

Expanded Metal Flat SS

Cpl 12-03-13

Location

Loc Qty

Loc Code

WA	0.0001156
119180	0.0001156
WA035	575.3276036
117197	102.9036
117896	29.49258
118153	76.8473
118955	82.17
119180	53.6958107
119729	28.1132686
120155	13.2387327
120318	188.866312

M304TS0.750W.065

Purchased

No

100 f

664.5479

43.5804

45.87411

**

M304TS0 750W 065

304 SQ Tube .75x.75x.065W

Cpl 12-03-13

Location

Loc Qty

Loc Code

MAT017	616.890429
120267	116.890429
120633	500
MAT018	41
7636	41
WA007	0.5907428
116763	0.5907428
WA035	6.0667
118181	6.0667

M117636 →

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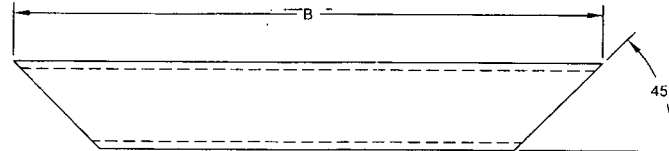
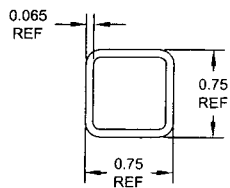
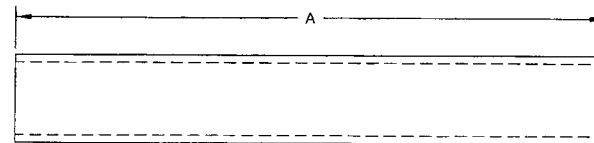
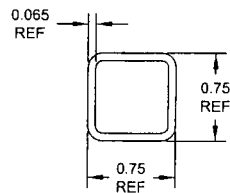
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PARTS LIST FOR D2512 BASKET LID ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D2512-1	2	—	25.50	RIB
D2512-3	2	—	95.30	RIB
D2512-5	6	30.84	—	RIB
D2512-7	3	30.63	—	RIB
D2232-1	2	N/A	N/A	HINGE PLATE
D2236	4	N/A	N/A	RIB
D2327-1	2	N/A	N/A	BUSHING
D2506	1	N/A	N/A	LABEL PLATE
D2581	2	N/A	N/A	MOUNTING BRACKET

80812 MLO
12/02/29



RELEASED
08-08-21-18



D2512-1/-3/-5/-7 NOTES:

- 1) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING
REF. DART SPEC M304TS0.750W.065
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST

E	INCORPORATED D1 & D2. MATERIAL FOR -1, -3, -5, & -7 WAS 0.060 WALL. SHT 3 ZN C4 TOLERANCE REMOVED FROM 95.30 DIM. DRAWING TRANSFERRED TO "B" FORMAT AND UPADTED TO CURRENT STANDARDS. SHT 3 VIEWS INVERTED FOR CLARITY. SHT 2 MESH MATERIAL CALLOUT UPDATED.	AJS	08.06.17
D	CHANGE HINGE	CP	01.04.19
C	REMOVE DOUBLE SKIN SECTION, ADDED MEMBERS, INCORP DEO 9074	DS	99.07.06
B	ADDED LATCH CHANNEL & LABEL PLATE	BW	96.05.24
A	NEW ISSUE	BW	95.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2512	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350/212)	NTS
DATE	08.06.17	<small>COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

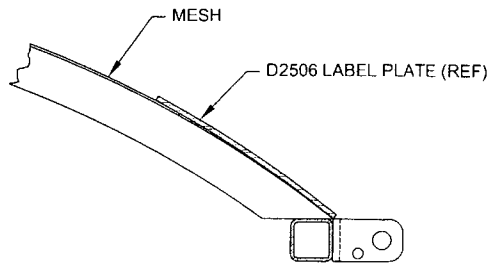
W/O:		WORK ORDER CHANGES					
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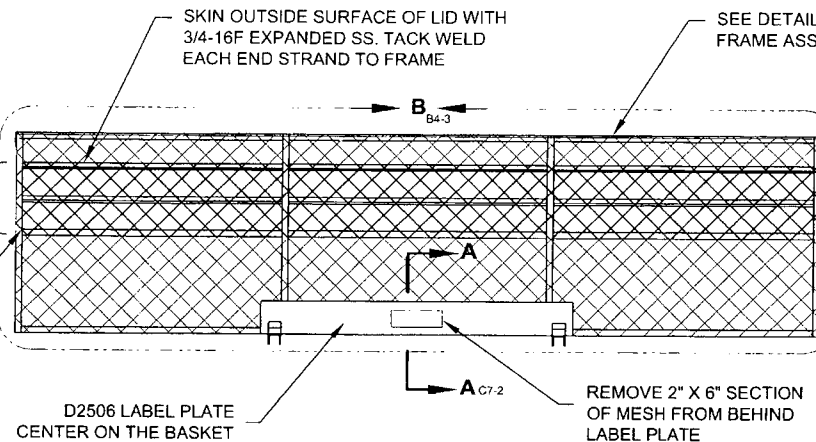
NOTE: Date & initial all entries



SECTION A-A
(ROTATED 90° CCW)

FINISH THIS SECTION ALONG
ENTIRE LENGTH PER NOTE 3
AFTER POWDER COAT.

TACK WELD MESH TO FRAME
AT EVERY AVAILABLE LOCATION
IN AREA TO BE ANTI-SKIDDED



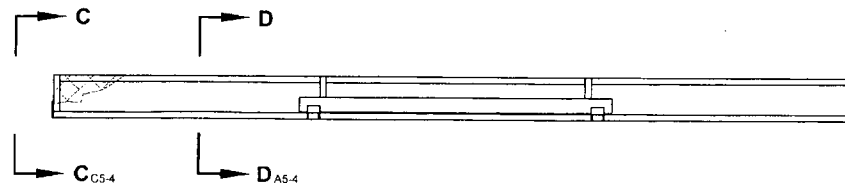
D2506 LABEL PLATE
CENTER ON THE BASKET

REMOVE 2" X 6" SECTION
OF MESH FROM BEHIND
LABEL PLATE



D2512 BASKET LID ASSEMBLY NOTES:

- 1) MESH MATERIAL: 3/4-16F EXPANDED SS
REF DART SPEC M304EX0.75-16F
- 2) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) SPRAY PAINT BLACK INSIDE SURFACE
APPLY BLACK ANTI-SKID TO OUTSIDE SURFACE PER DART QSI 005 4.4
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: N/A
- 9) WELD PER DART QSI 004



RELEASED
08-05-21/11/17

DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2512	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350/212)	NTS
DATE	08.06.17	COPYRIGHT © 1995 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS UNCLASSIFIED AND IS SUPPLIED ON THE UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

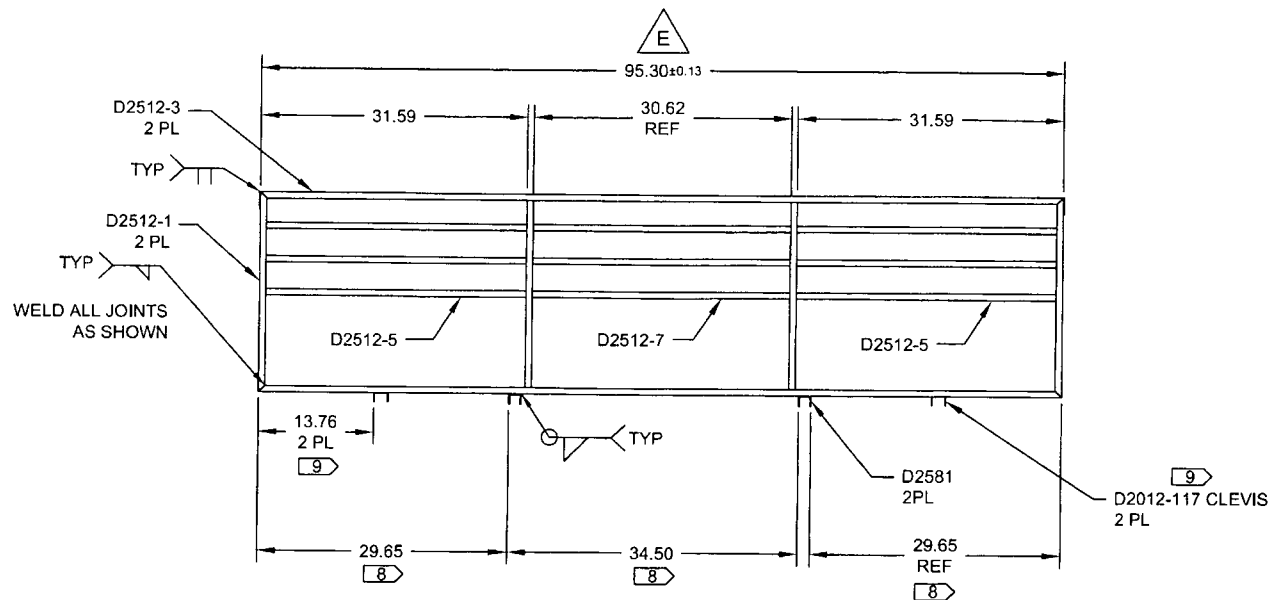
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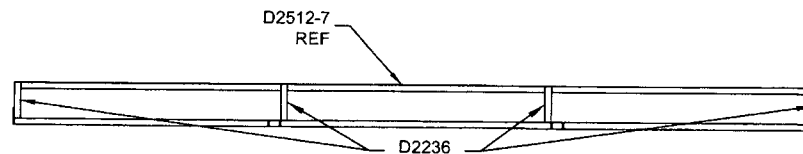
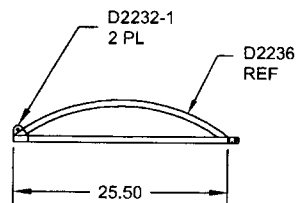
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DETAIL B C3-2
FRAMEWORK ONLY SHOWN FOR
CLARITY



NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) LOCATE IN CONJUNCTION WITH ADJACENT D2581 ON BASKET BASE ASSEMBLY
- 9) FOR D130-701-041 ONLY

RELEASED
08.06.17

DESIGN	BW	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	J	DRAWING NO.	REV. E
MFG. APPR.	D	D2512	SHEET 3 OF 4
APPROVED	AP	TITLE	SCALE
DE APPR.	HA	BASKET LID ASSEMBLY (350/212)	NTS
DATE	08.06.17	COPYRIGHT © 1995 BY DART AEROSPACE LTD	
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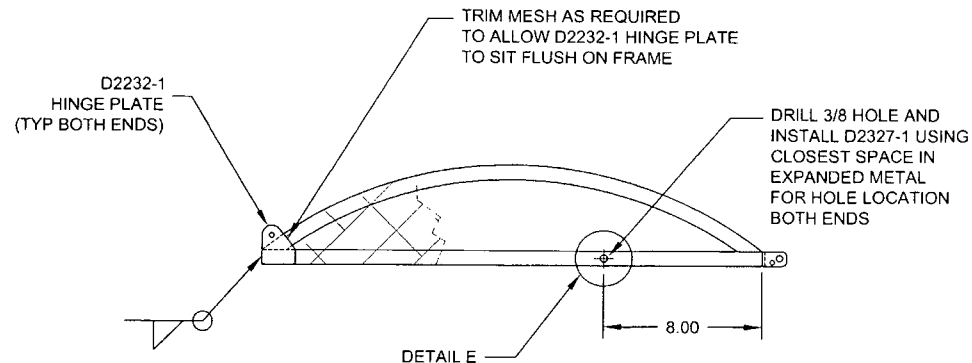
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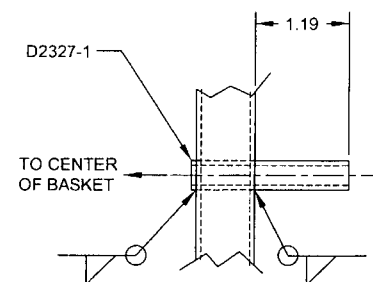
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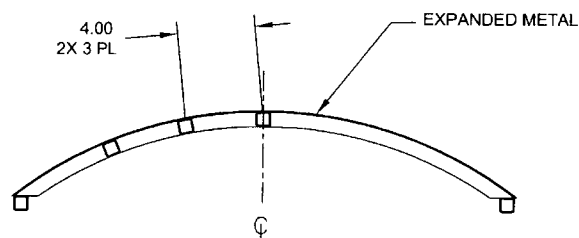
20812



VIEW C-C SIMILAR BOTH END RIBS A5-2



DETAIL E C6-4



SECTION D-D SAME BOTH CENTER RIBS A4-2

RELEASED
05 06 21/17

DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2512	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350/212)	NTS
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries